

Work Order ID 81626***81626***

Page 1

March-16-12 8:41:33 AM

Item ID: D4095-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad Assembly

Start Date: 16/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/03/16

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-7)

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B12-3-25

(12)

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-3-25

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5.2/5/26

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81626***81626***

Page 2

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Start Date: 16/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Form as per dwg

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Weld per dwg A/R Hardcoat S.S. Batch: M120392 0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

Sp 12/03/27

S 12/03/27

(12)

(12)

12

12-03-29 JBL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 81626***81626***

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Start Date: 16/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 120858

(47)

A2

12 - 3 - 29

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 81626***81626***

Page 4

March-16-12 8:41:33 AM

Item ID: D4095-047

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearpad Assembly

Stop ***NS2***

Start Date: 16/03/2012 Start Qty: 12.00

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

124 4 M 12/03/13

200

Identify as per dwg & Stock Location: EP-2

0.00

200

Packaging

Memo

0.00

Packaging

124 4 M 12/03/13

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/3/30

C212103/30

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 8:41:37 AM

Page 1

Work Order ID: 81626

81626

Parent Item: D4095-047

D4095-047

Parent Item Name: Wearpad Assembly

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	249.9860		1.764			

M304S16GA

304/316 Sheet .063

**

B12-3-25

Location

Loc Qty

Loc Code

MAT020

249.986

119653

17.35

120866

73.5

120877

159.136

120866

(12)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.11.08	New Issue P/O D4095-047	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

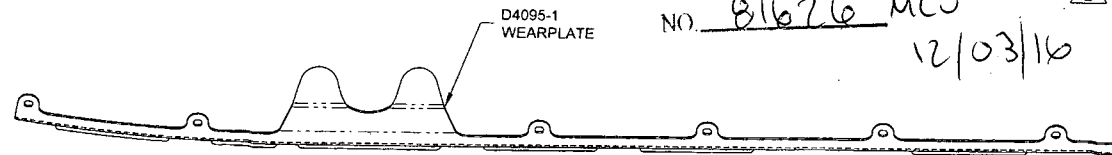
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

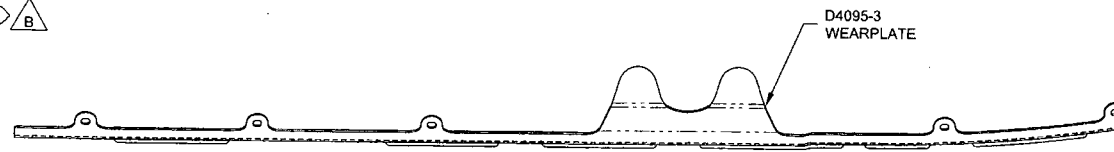
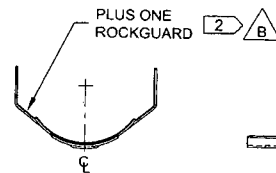
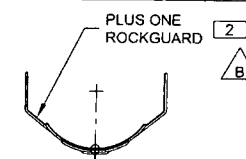
NO. 81676

MLJ
12/03/16

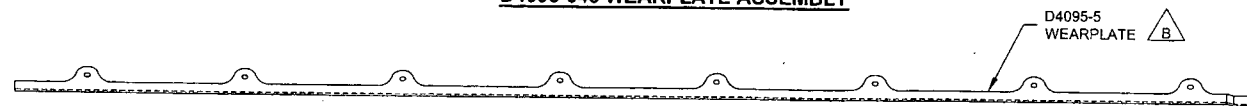
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



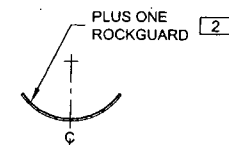
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4095	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
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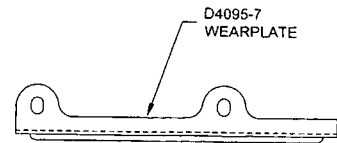
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

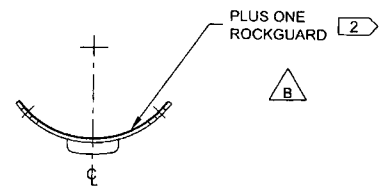
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

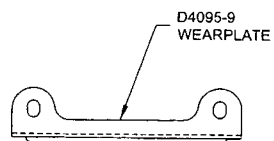
NOTE: Date & initial all entries



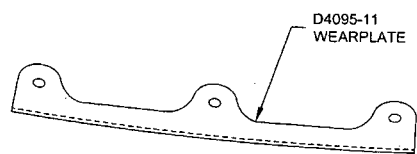
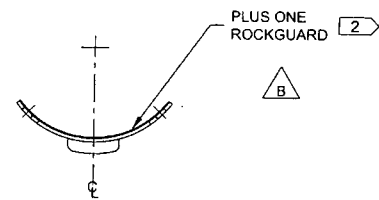
D4095-047 WEAR PAD ASSEMBLY



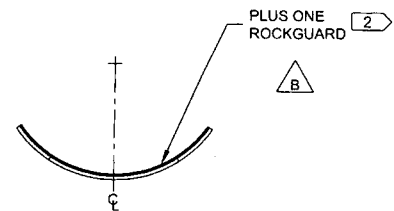
81626



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



RELEASED
2011-10-31
WMB

DESIGN	J	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 2 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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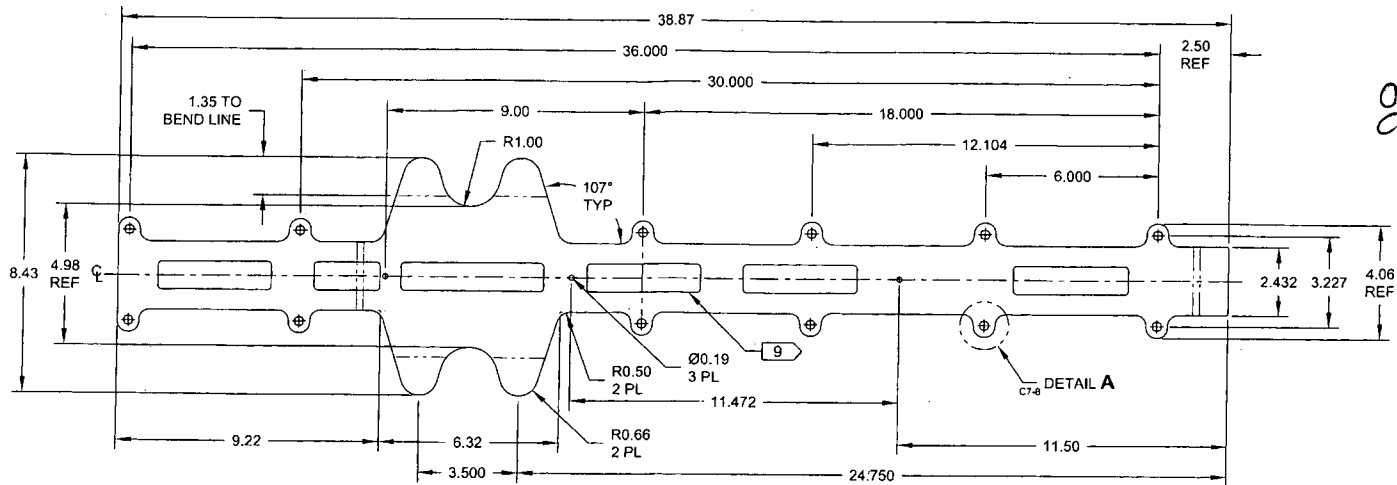
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

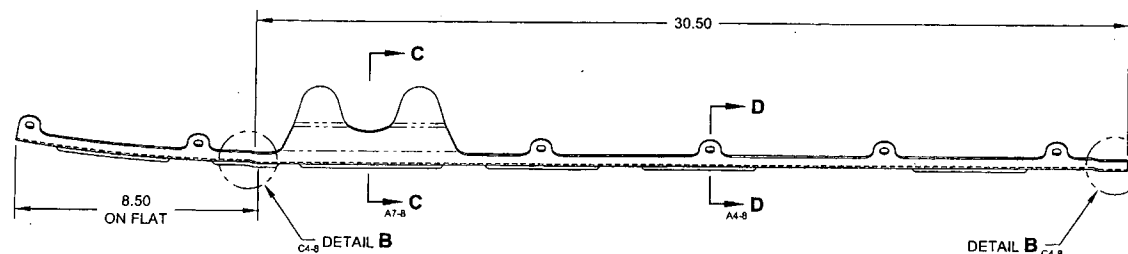
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT \bar{C}

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 3 OF 8
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DE APPR.	140	WEARPLATE	NTS
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2011-10-31
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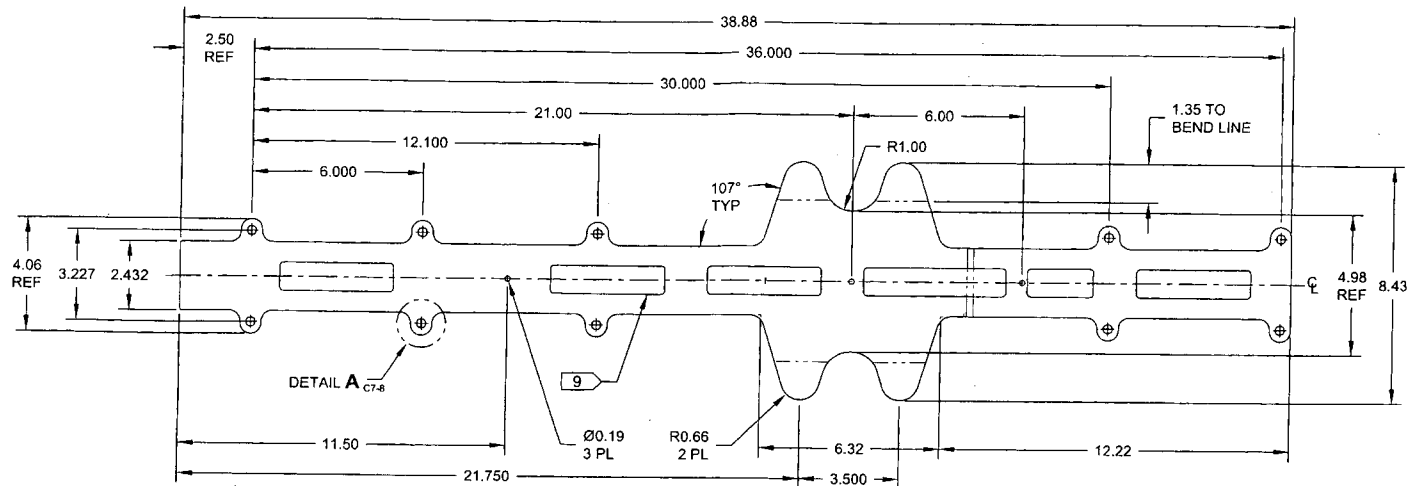
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

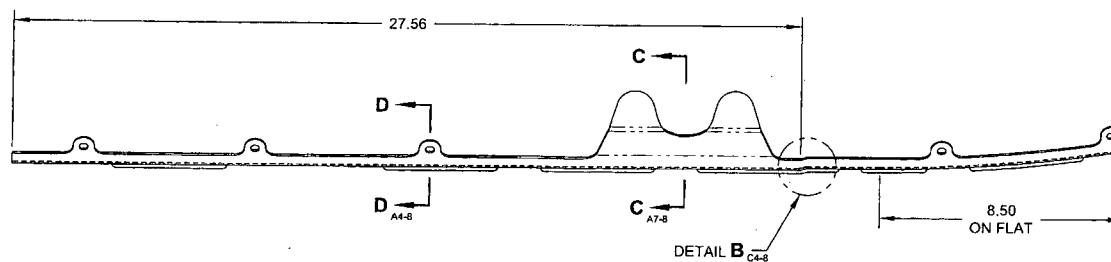
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 4 OF 8
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RELEASE
2011-10-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

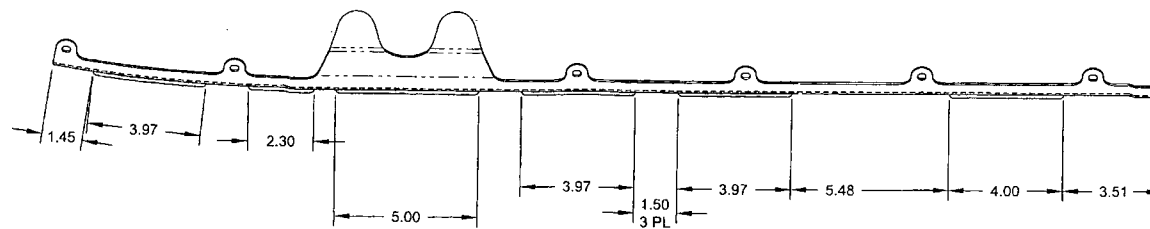
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

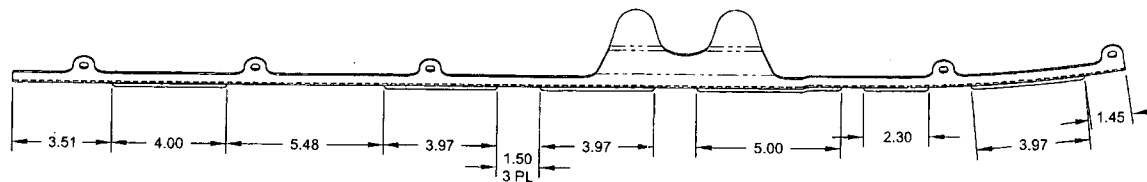
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

21626



D4095-1 WELDING DETAIL 



D4095-3 WELDING DETAIL 

RELEASED
2011-10-31
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DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 5 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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W/O:		WORK ORDER CHANGES					
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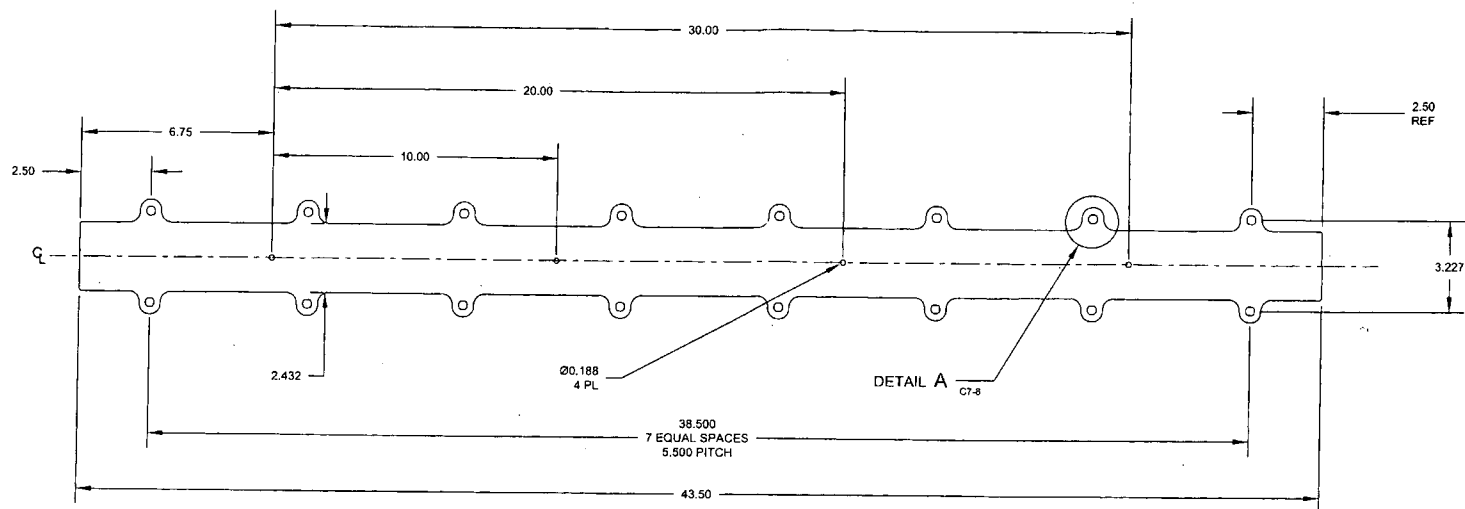
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

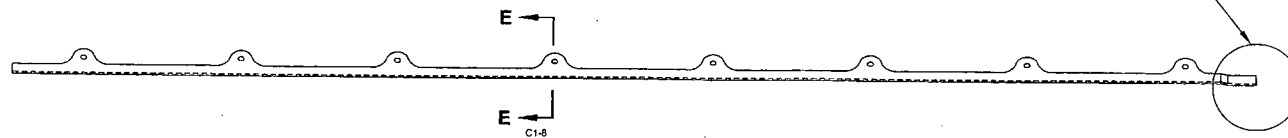
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81626



D4095-5F FLAT PATTERN



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

RELEASED
2011-10-31
JW

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 6 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	NTS
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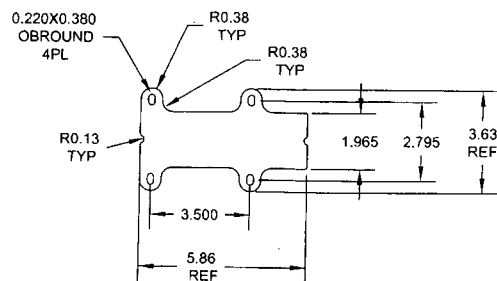
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

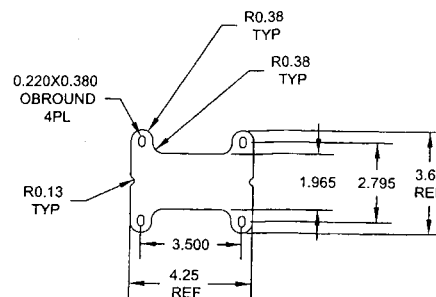
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

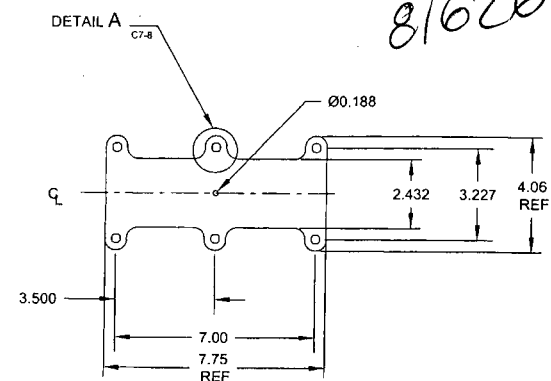
NOTE: Date & initial all entries



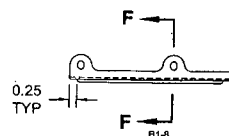
D4095-7F FLAT PATTERN 1



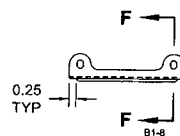
D4095-9F FLAT PATTERN 1



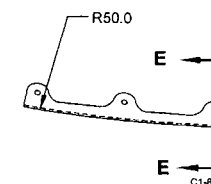
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 7 OF 8
APPROVED	140	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

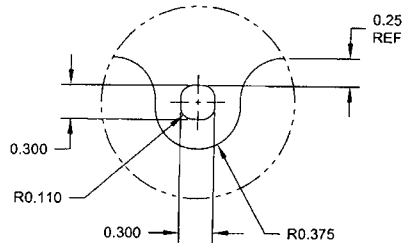
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

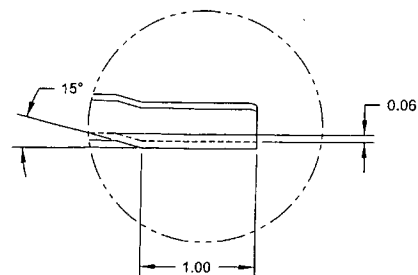
NOTE: Date & initial all entries

81626



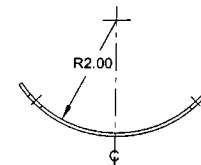
DETAIL A: TAB DETAIL

SCALE 4X
C3-3
C6-4
D3-8
D2-7

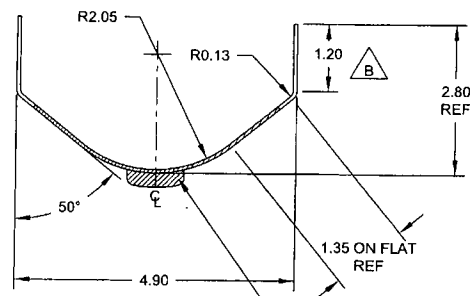


DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-3
B6-3
B3-4
B2-6



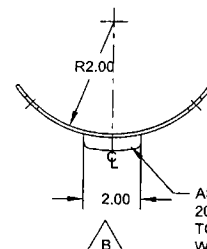
SECTION E-E
SCALE 2X
B5-6
B2-7



SECTION C-C

SCALE 2X
B5-3
B4-4

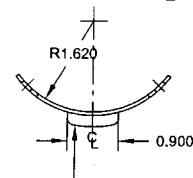
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D

SCALE 2X
B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X
B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-3
MP

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4095	SHEET 8 OF 8
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries